

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58839

Wednesday, May 19, 2010 1:37:09 PM



Page 2

Item ID: D3700-1

Accept



Setup Start



Revision ID:

Item Name: Inboard Window Doubler

Stop



Start Date: 5/19/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210-5-31

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1110/05/31210-5-31

150

Identify as per dwg & Stock Location: 83

0.00



Packaging

Memo

0.00

Packaging

10-5-31 (2x) 80

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Page 3

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Accept



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Revision ID:

Item Name: Inboard Window Doubler

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Start Date: 5/19/2010 Start Qty: 2.00



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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/01

R/10-6-01
(2)

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Picklist Print

Wednesday, May 19, 2010 1:37:15 PM

Page 1

Work Order ID: 58839



Parent Item: D3700-1



Parent Item Name: Inboard Window Doubler

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	161.2419	0.29	16.		



6061-T6 .080 Sheet



810-5-27

Location

Loc Qty

Loc Code

MAT21

161.24193

113438

2.7512

114351

158.49073

114381

(2)

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DART AEROSPACE LTD		Work Order:	58839
Description: Inboard Window Doubler		Part Number:	D3700-1
Inspection Dwg: D3700	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST


☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	IB
Date:	10-5-27

Audited by:	8
Date:	10/13/22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ	

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D3700-1 INBOARD WINDOW DOUBLER

D3700-3 OUTBOARD WINDOW DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58839
BS10-519

RELEASED
09/03/18

B	ADDED 0.25" TO TOP PROFILE OF D3700-1 (ZN D8-2); REDIMENSION PARTS; REMOVED REFERENCES TO DXF FILES (NOTES 8 AND 9).	MB	09.03.18
A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	09.03.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

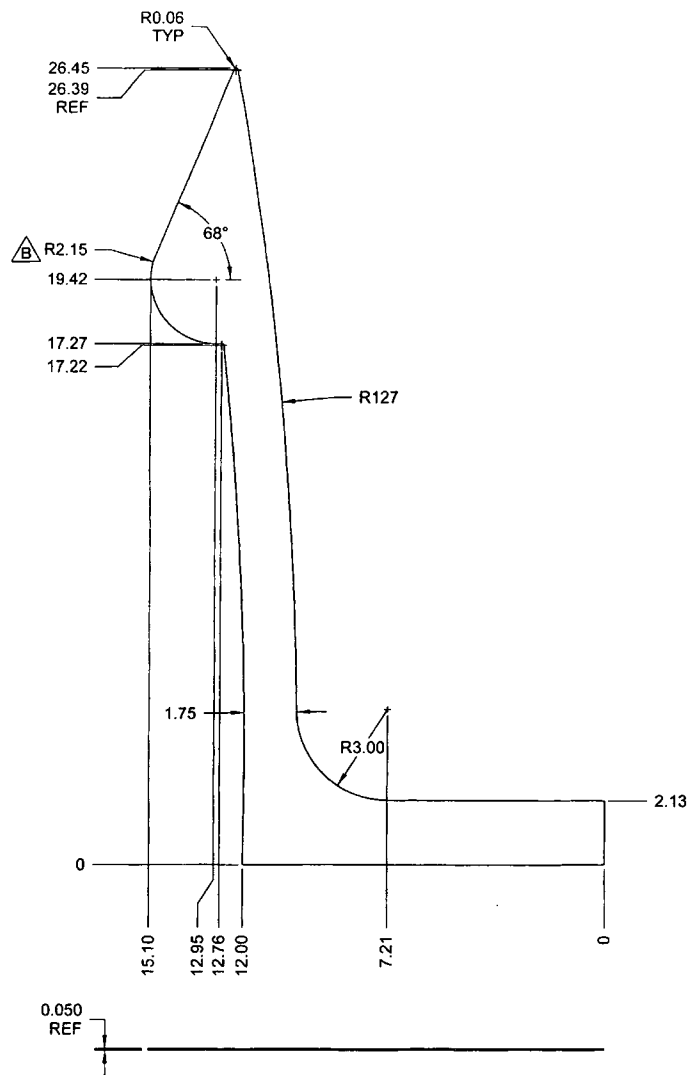
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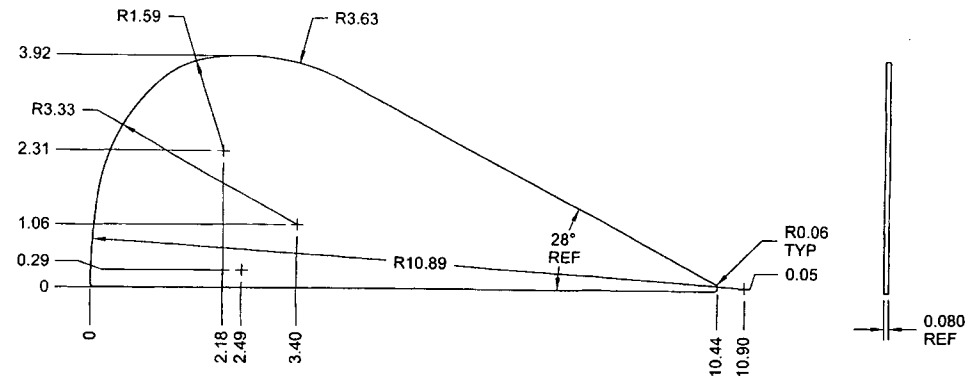
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D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

RELEASED
09/04/09

NOTES:

1) MATERIAL:

- D3700-1: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- D3700-3: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED





5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE

POINT PERMANENT INK MARKER

7) WEIGHT: D3700-1 = 0.20 lbs

D3700-3 = 0.37 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	09.03.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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